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DART AEROSPACE LTD	Work Order:	20773
Description: Chafing Shield	Part Number:	D3190-1
Dwg: D3190 Rev. A	Qty:	4
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	RF	04.04.20	4
2	GA	Cut blank: 9.25" x 3.13" Material: AISI 304/316 SS 0.020" thick sheet (M304S25GA)	MJ	04-05-05	4
3	GA	Grind corner as per Dwg D3190	MJ	04-05-05	4
4a	GA	Deburr	AM	04-05-05	4
4b	QC5	Inspect	AM	04-05-05	4
5	GA	Roll as per Dwg D3190	2	05-01-04	4
6	QC5	Inspect work to Step 5	B	05-01-05	4
7	LG	Identify and Stock	JL	05-01-06	4
8	AC	Cost / part 13.37	SAC	05-01-07	4
9	DC	Close W/O 13,37 Inspect Level 21	RF	05.01.14	4

Rev	Date	Change	Revised By	Approved
A	03.05.26	New issue	KJ/RF	RF

RELEASED
03.05.27 RF

Work Order:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR 20773		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
04.05.05	2	Scrap 4 pieces 9.25 x 3.130 Because the blade of Broke is not sharp. Try to fix the pieces or with grind	Initial P Parashu	Scrap 4 pieces destroy made 4 new one with hand made	ml 04.05.05	BS 05.01.12	BS Parashu	BS 05.01.12

PAR#: N/P

Fault Category: Manuf/Misc.

DQA: S.H.

Date: 05/01/13

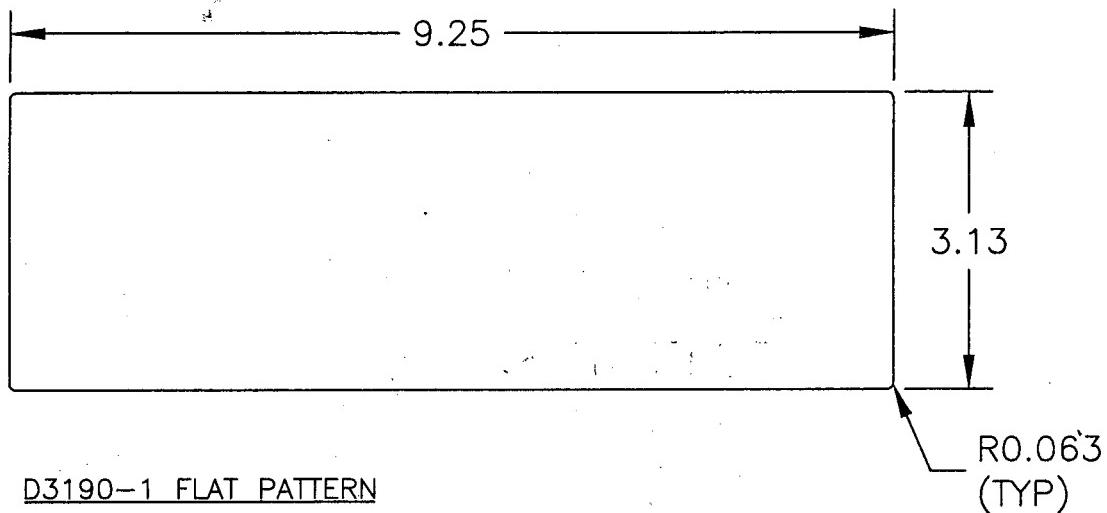
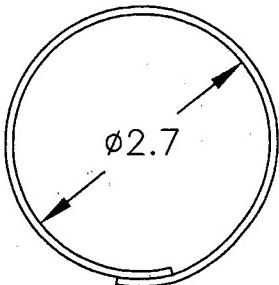
QA: N/C Closed: J.J.

Date: 05.01.13

DART

DESIGN <i>[initials]</i>	DRAWN BY <i>[initials]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3190	REV. A SHEET 1 OF 1
DATE 03.05.16		TITLE CHAFING SHIELD	SCALE 1:2
A	03.05.16	NEW ISSUE	

RELEASED
03.05.22 *[initials]*

D3190-1 FLAT PATTERN

D3190-1 ROLLING DETAIL
NOT TO SCALE
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

D3190-1 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304\$25GA)
 - 2) FINISH: NONE
 - 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
- NO. 20773

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 27, 2004
03:08 pm

Work Order No	:	0020773	Department Code:	
Project Name	:	D3190-1	Burden Flags	: NNNNNNNN
Project For	:	WK420	WO Status	: Open
Work Order Type	:	Main	Invoice State	: Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	D3190-1	Invoice Number	:
Description	:	Chafing Shield	Invoice Amount	: 0.00
Manufactured	:	Yes		
Amount Req'd	:	4	Order Entry No	:
Amount Done	:	0	OE Value	: 0.00
Start Date	:	04-27-04	Est Margin	: 0.000%
Est Finish Date	:	05-19-04	Actual Margin	: 0.000%
Act Finish Date	:			
Drawings Reqd	:	No		
Ok for Approval	:			
Approval Rec'd	:			\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
 Burden	 :	 0.00	 0.00	 0.00	
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/ (Loss)	: 0.00	0.00